

Date: Monday, 5/1/2006 3:59:44 PM  
 User: Kim Johnston

## Process Sheet

22

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION  
 Job Number : 26885  
 Estimate Number : 12188  
 P.O. Number : N/A Part Number : D205706013  
 This Issue : 5/1/2006 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : N/A  
 Previous Run : 26665 Material : N/A  
 Written By : *[Signature]* Due Date : 5/30/2006 Qty: 3 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
 Photocopy bluefile and create labels per PPP D205-706-013CHG001

KS 06.05.12 (2)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2001-4 Valve Assembly B23276 ✓

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3262-041 Canister Assembly B26761 1x 26416 AR 06/06/15

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3264-1 Bracket B23285 ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D329710121

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0121 Hose Assembly B26896 ✓

7.0

D329710130

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0130 Hose Assembly B26897 ✓

8.0

D329730350

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-3-0350 Hose Assembly B26898 ✓

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-001 Tube Assembly B23293 ✓

10.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-009 Tube Assembly B23297 ✓

11.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : **3.0000** Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3299-1 Fitting B23301A ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 26885

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

~~B23302~~ B23302 1mcp ✓

B23012 2mcp ✓

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

Doubler

B23304 ✓

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

B23013 ✓

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

B22791B 1mcp ✓ B22791A 1mcp ✓ B23306 1mcp ✓

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

B26688 ✓

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M15205 ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date: Monday, 5/1/2006 3:59:45 PM  
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Job Number: 26885

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~3~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17654 ✓

19.0

AN8156D

Union-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~4~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M17654 \$mcp

M16895 1mcp ✓

20.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~8~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M19620 ✓

21.0

AN9246D

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~8~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M17654 1mcp ✓

22.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : ~~18~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

100743 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D205706013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	AN960JD10L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~8.0000~~ <sup>12</sup> Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

M18235 ✓

24.0	AN960JD916	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~4.0000~~ <sup>6</sup> Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

M100857 ✓

25.0	MS21042L3	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~8.0000~~ <sup>12</sup> Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M100393 ✓

26.0	MS21919WDG9	Clamp
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Comment: Qty.: 5.0000 Each(s)/Unit Total : ~~10.0000~~ <sup>15</sup> Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

M17772 ✓

27.0	MS21919WDG12	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~3.0000~~ <sup>3</sup> Each(s)

Clamp

Qty Part Number

Description

Batch

1 MS21919WDG12

Clamp

M12010 ✓

28.0	MS21919WDG16	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~6.0000~~ <sup>4</sup> Each(s)

Clamp

Qty Part Number

Description

Batch

2 MS21919WDG16

Clamp

M16322 ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 06/06/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18048 ✓

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

M17654 ✓

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M16323 ✓

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev: B

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



06/06/16 (3)  
06/06/19 (3)  
4 06/06/19

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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